PROJECT TITLE : CIGARETTE DEVELOPMENT 1

PERIOD COVERED : JUNE 27 - AUGUST 21 1981

WRITTEN BY : Singer-Z. (ZDS)

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365 BARBARA

Objective

K : 15 mg/cig.
N : 1 mg/cig.
Format : 7.95 / 20 / 84 mm

Summary

Prototype 41 T is being product tested against CAMEL FILTER and MARLBORO DB.
Due to some rumours concerning the lack of impact which could be detected in the first two puffs of the above-mentioned prototype, the German Marketing people came up with a suggestion on how to lessen such a negative characteristic.

Description of samples and results

Two trials were carried out on prototype 41 T by taking the less porous cigarette paper Pela 54 and a non-porous tipping paper.
The description of these two prototypes and their comparison with the original prototype is stated in the table on the next page.
The results of taste evaluation are not yet available.

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Source: https://www.industrydocuments.ucsf.edu/docs/lnhk0000

PROJECT NAME : B A R B A R A | PROJECT NO : 365 | PROJECT LEADER : ZDS | DATE : August 24th 1981

PROTOTYPE NO		44 P	45 P	41 T
BLEND NO		DB0136505N25 (containing 11 % of ET)		
TA	%	1.67	1.67	1.71
NITRATE-NITROGEN	%	0.20	0.19	0.20
REDUCING SUGARS	%	9.9	9.9	9.8
FORMAT : DIAMETER	mm	7.90	7.90	7.93
FILTER LENGTH	mm	21	21	21
CIGARETTE LENGTH	mm	84	84	84
TOTAL WEIGHT	mg/cig.	1025	1015	1020
TOBACCO WEIGHT AT 12 % O.V.	mg/cig.	795	783	784
CIGARETTE RTD	mm WG	124	134	114
DILUTION	%	16	0	12
CIGARETTE PAPER		Pela 22 / 54	Wattens 60	Wattens 60
TIPPING PAPER		Z3 / 30	Non-porous	Z3 / 30
FILTER : TYPE		Single	Single	Single
TOW		3.4 I / 46'000		
PAPER		FU-POV 40	FU-POV 40	FU-POV 40
RTD	mm	68		
TAR (K)	mg/cig.	14.3 (12.6)	15.8 (13.8)	14.7 (12.9)
SN (N)	mg/cig.	1.06 (0.91)	1.18 (1.01)	1.03 (0.98)
CO	mg/cig.	17.5	17.3	18.1
NO	mg/cig.	0.20	0.24	0.21
PUFF COUNT		7.6	6.9	9.1

THE CIGARETTES ARE SMOKED ON A PM 20 PORTS.

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Source: https://www.industrydocuments.ucsf.edu/docs/lnhk0000

MASKI

Objective

To launch an American blend cigarette in a 20's or 24's pack having no influence on the MARLBORO RED sales in Germany.
K = 10 - 11 mg/cig.
N = 0.8 mg/cig.

Summary

It was decided to use the standard European MARLBORO LIGHTS (MLY) but with filter or tipping paper modifications in order to bring the analytical figures within the objectives. The tipping paper used should not be wider than 28 mm.

Description of samples and results

Using the MLY blend, two prototypes of different designs were produced in PMG Munich.

Version No		1	3
Format : diameter	mm	7.95	7.95
filter length	mm	21	25
cigarette length	mm	84	84
Cigarette paper		Wattens 60 ----------	
Tipping paper		Z4 / 120 eletro-perforated	
Filter : type		BSL - 126	MER - 100
tow		2.5 Y/51'000	2.5 Y/48'000
paper		FU-POV 40 L	FU-POV 40 L
K	mg/cig.	11.2	9.7
N	mg/cig.	0.77	0.68
Puff count		10.7	9.7

The tipping papers used on both versions have the same porosity but different widths :

Version No		1	3
Tipping paper width	mm	25	28
Over-lap	mm	4	3

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Until now, the cigarette and tipping paper over-laps have never been shorter than 4 mm. The trial showed that cigarettes with 3 mm over-lap can be produced. However, it should be pointed out that the (industrial) production cannot avoid variations of +/- 1 mm, which means that the over-lap obtained is from 2 to 4 mm. The 2 mm attachment of the filter tip to the tobacco column is, in our opinion, not sufficient.
Both versions were submitted to Panel A for taste evaluation. Version No 3 was selected as the only alternative for this project as it is a good quality product, similar in taste and character to MLY. CO/NO analyses are under way in FTR Neuchâtel.

L & M FINLAND

Objective

Transfer of the production of L & M to ATO.

Description of samples and results

In order to be in line with the Pan-European L & M product, cigarettes were made using the MLF blend and L & M flavours. The non-tobacco materials used were the same as those of the MLF SF.
A cigarette sample of the ATO first trial was analysed in FTR Neuchâtel and taste evaluated by the expert Panel A in Lausanne.

		L & M S F
Format	mm	7.89/20/79
Total weight	mg/cig.	993
Tobacco weight at 12 % MC	mg/cig.	766
Total RTD	mm WG	104
Dilution	%	0
Tar	mg/cig.	15
SN	mg/cig.	1.04
CO	mg/cig.	14.4
NO	mg/cig.	0.23
Puff count		8.1

The analytical results obtained are within the standard.

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Source: https://www.industrydocuments.ucsf.edu/docs/lnhk0000

As regards the physical parameters of the cigarette, the diameter of 7.89 mm is out of the acceptable limits (7.95 +/- 0.05 mm).
As far as the organoleptic characteristics are concerned, the submitted sample gives a softer and milder taste in comparison with the current product.

358 VOITTO

Objective

To re-engineer the existing BELMONT NO 1 cigarette in order to bring the product more in line with the BELMONT family.

Description of samples and results

Using the tobacco blend PMS ex-PMG Munich, cigarette prototypes of various designs were produced. Two prototypes which are within the target figures differ in the cigarette papers used (see table on the next page).

Follow-up

- These two prototypes should be reproduced with a freshly prepared PMS blend containing 006 ET "special composition" (until now, the ET ex-Onnens was used).
- A trial will be carried out with a 110-6 cigarette paper from Mauduit (which replaced the Ecusta 708 for the PMS production).
- A trial will be carried out with a single acetate filter. The existing double filter (12.5/12.5 acetate/DICO) is well accepted as far as the taste is concerned. However, great variations in dilution were observed. The problem encountered can be explained by the fact that the dilution zone is located just at the join of the two plugs.

Z. Finger

ZDS/cap/AUGUST 25, 1981

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Source: https://www.industrydocuments.ucsf.edu/docs/lnhk0000

PROJECT NAME : V O I T T O		PROJECT NO : 358	PROJECT LEADER : ZDS	DATE : August 25th 1981
PROTOTYPE NO		6 P	8 P	BELMONT NO 1
BLEND NO		PMS	PMS	32 BEP (CIR 4-5 1981)
TA	%	1.93	1.80	1.63
NITRATE-NITROGEN	%	0.24	0.22	0.32
REDUCING SUGARS	%	7.1	8.7	1.2
FORMAT : DIAMETER	mm	7.97	7.99	7.97
FILTER LENGTH	mm	25	25	25
CIGARETTE LENGTH	mm	80	80	80
TOTAL WEIGHT	mg/cig.	895	907	862
TOBACCO WEIGHT AT 12 % O.V.	mg/cig.	581	589	529
CIGARETTE RTD	mm WG	71	68	156
DILUTION	%	72	72	47
CIGARETTE PAPER		Ecusta 708	Wattens 100	Wattens 60
TIPPING PAPER		5 M. 2.0.1.1	5 M. 2.0.1.1	Mechanically perforated
FILTER : TYPE		Double	Double	Double
TOW		2.5 Y / 48 / DICO	2.5 Y / 48 / DICO	2.5 Y / 75 / DICO
ADDITIVE		---	---	---
PAPER		FU-POV 100	FU-POV 100	FU-POV 150
RTD	mm	106	105	
DPM	mg/cig.	1.4	1.4	1.3
SN	mg/cig.	0.17	0.14	0.16
CO	mg/cig.	3.2	3.1	3.8
NO	mg/cig.	0.05	0.04	0.10
PUFF COUNT		8.2	8.3	6.7

THE CIGARETTES ARE SMOKED ON A PM 20 PORTS.

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